

Work Order ID 108950

October-30-13 9:57:47 AM

Ship Nov. 5

108950

~~PRELIMINARY~~

per ECN 668
13-11-01
Page 1
MF 13-11-01

Item ID: D4950-043

Accept

N900040100

Setup Start

NS1

Revision ID: ~~PRELIM~~

Stop

NS2

Item Name: Tailboom Mount

Start Date: 10/30/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/04/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4950

PA1 A per ECN 13-668 MF

13-10-21

100

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- assemble as per dwg D4950

8

13/11/01

DAS
36
9-89

110

110

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DAS
27
9-89

13 14 01

8

120

120

Packaging

Packaging

Identify as per dwg & Stock Location (X) ST 125

0.00

Memo

(X) PPP 108948

0.00

8x

DAS
28
9-89

13-11-1

Work Order ID 108950

108950

Page 2

October-30-13 9:57:47 AM

Item ID: D4950-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: PRELIM Stop ***NS2***
 Item Name: Tailboom Mount
 Start Date: 10/30/13 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 11/04/13 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

[Signature] 13-11-05
 MF 13-11-04

POSITIVE RECALL
 EFFECTIVE 13-10-30
 RELEASED
 AUTH *[Signature]*
 DATE
 per ECN- 13-668
 MF 13-10-31

Picklist Print

October-30-13 9:57:47 AM

Page 1

Work Order ID: 108950
Parent Item: D4950-043
Parent Item Name: Tailboom Mount

Start Date: 10/30/13
Start Qty: 6.00

Required Date: 11/04/13
Required Qty: 6.00

Comments: IPP REV:A 13.09.24 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4950-3 Plate		Manufactured	No				Each	0.0000		68	13/11/01		DAS 36 9-89
D3868-3 Spacer		Manufactured	No				Each	84.0000		68	13/11/01		DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST068		84				8			
				106578		84							
D3868-5 Spacer		Manufactured	No				Each	2.0000		68	13/11/01		DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		2				2			
				45582		2							
MS20426AD3-15 Rivet		Purchased	No				Each	1,732.0000		2432	13/11/01		DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		16							
				116289		16							
				ST334		1716							
				105055		39							
				120123		1677							

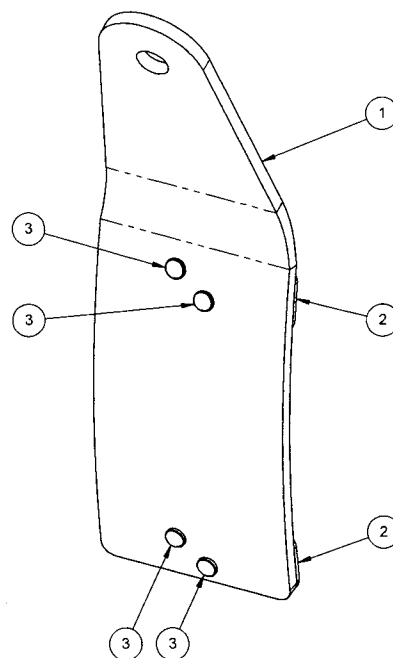
DAS
36
9-89
13/11/01

M4533
33

DAS
36
9-89
13/11/01

M4533
32x

ITEM NO.	QTY -041	PART NUMBER	DESCRIPTION
	X	D4950-041	TAILBOOM MOUNT
1	1	D4950-1	MOUNT
2	2	D3866-1	SPACER
3	4	MS20426AD3-6	RIVET



D4950-041 TAILBOOM MOUNT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4950-041" AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.12 lbs

PRELIMINARY ISSUE

13.09.23

PA1	NEW ISSUE	MB	13.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.09.23		

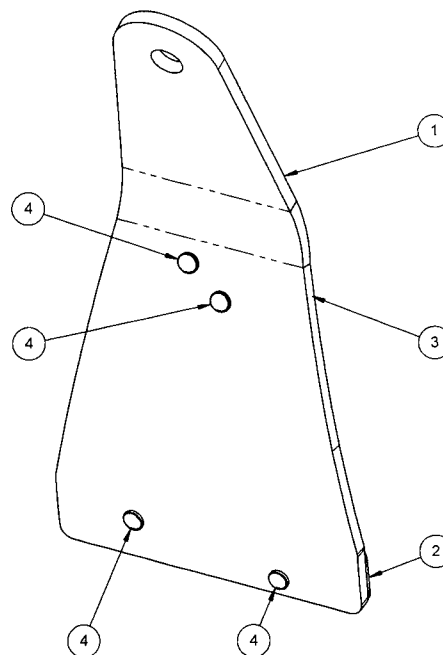
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4950** REV. PA1
SHEET 1 OF 6

TITLE **MOUNT** SCALE **NTS**

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ITEM NO.	QTY -043	PART NUMBER	DESCRIPTION
	X	D4950-043	TAILBOOM MOUNT
1	1	D3866-3	MOUNT
2	1	D3868-3	SPACER
3	1	D3868-5	SPACER
4	4	MS20426AD3-6	RIVET



D4950-043 TAILBOOM MOUNT

NOTES:

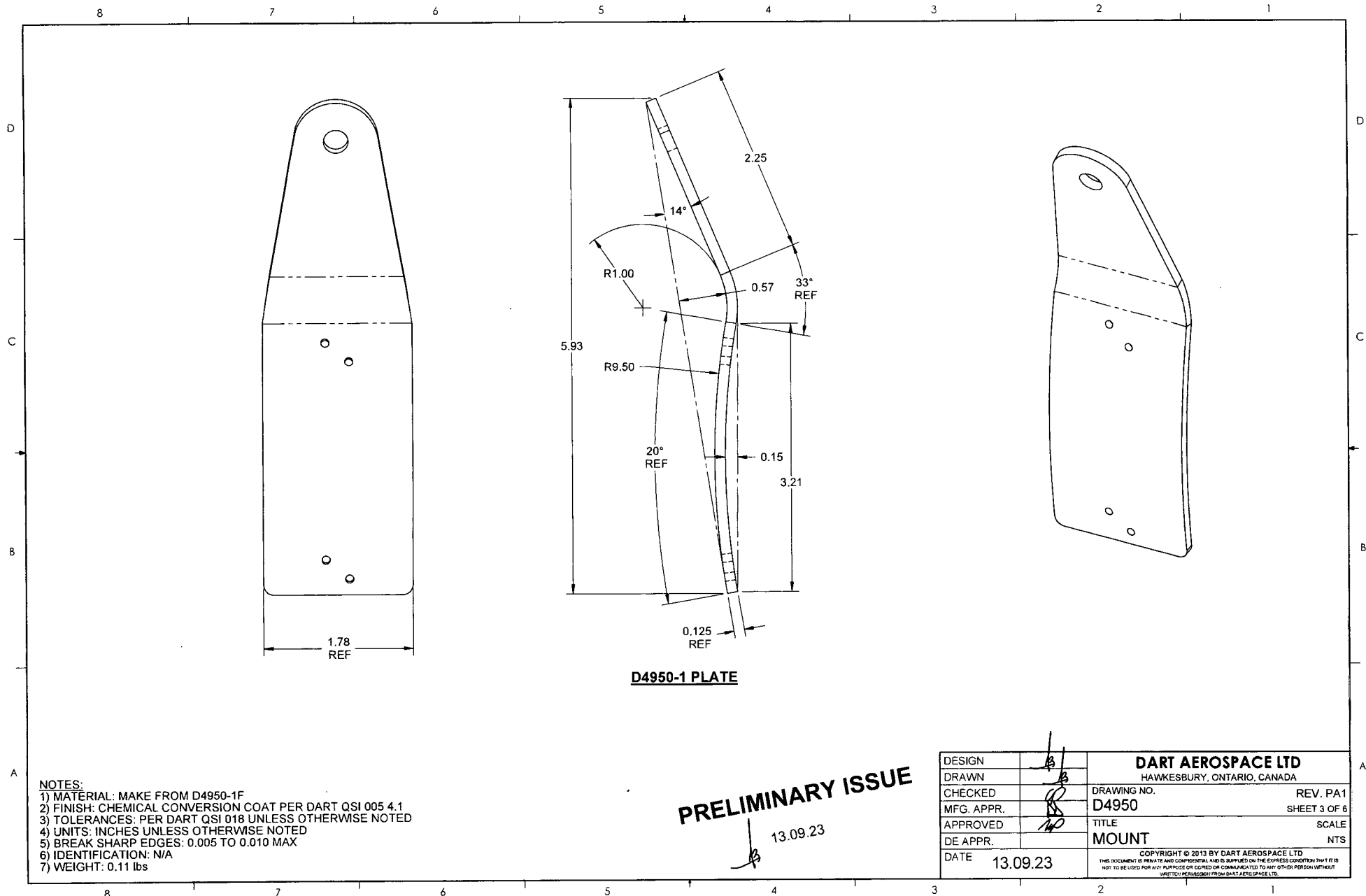
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4950-043" AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.15 lbs

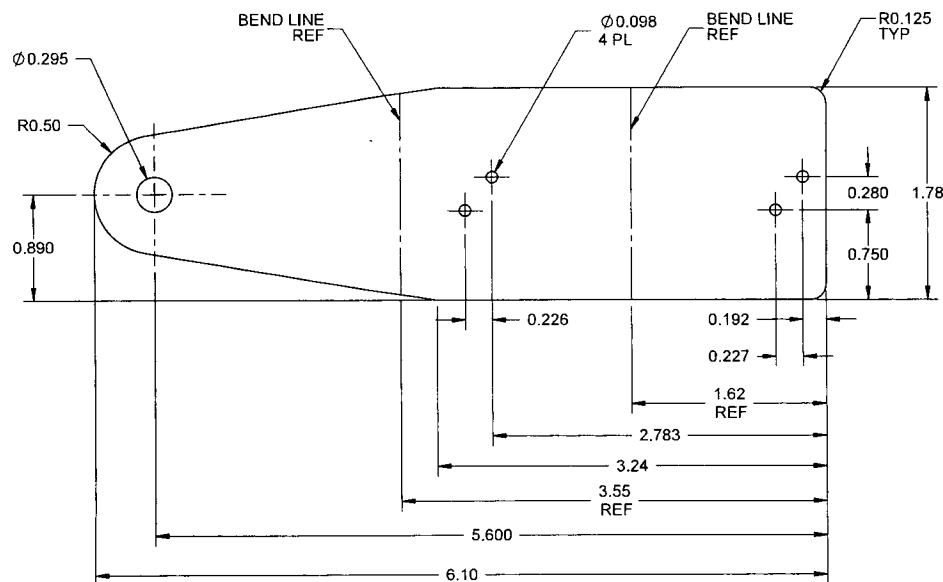
PRELIMINARY ISSUE

13.09.23

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. PA1
MFG. APPR.		D4950 SHEET 2 OF 6
APPROVED		TITLE SCALE
DE APPR.		MOUNT NTS
DATE	13.09.23	

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D4950-1F FLAT PATTERN

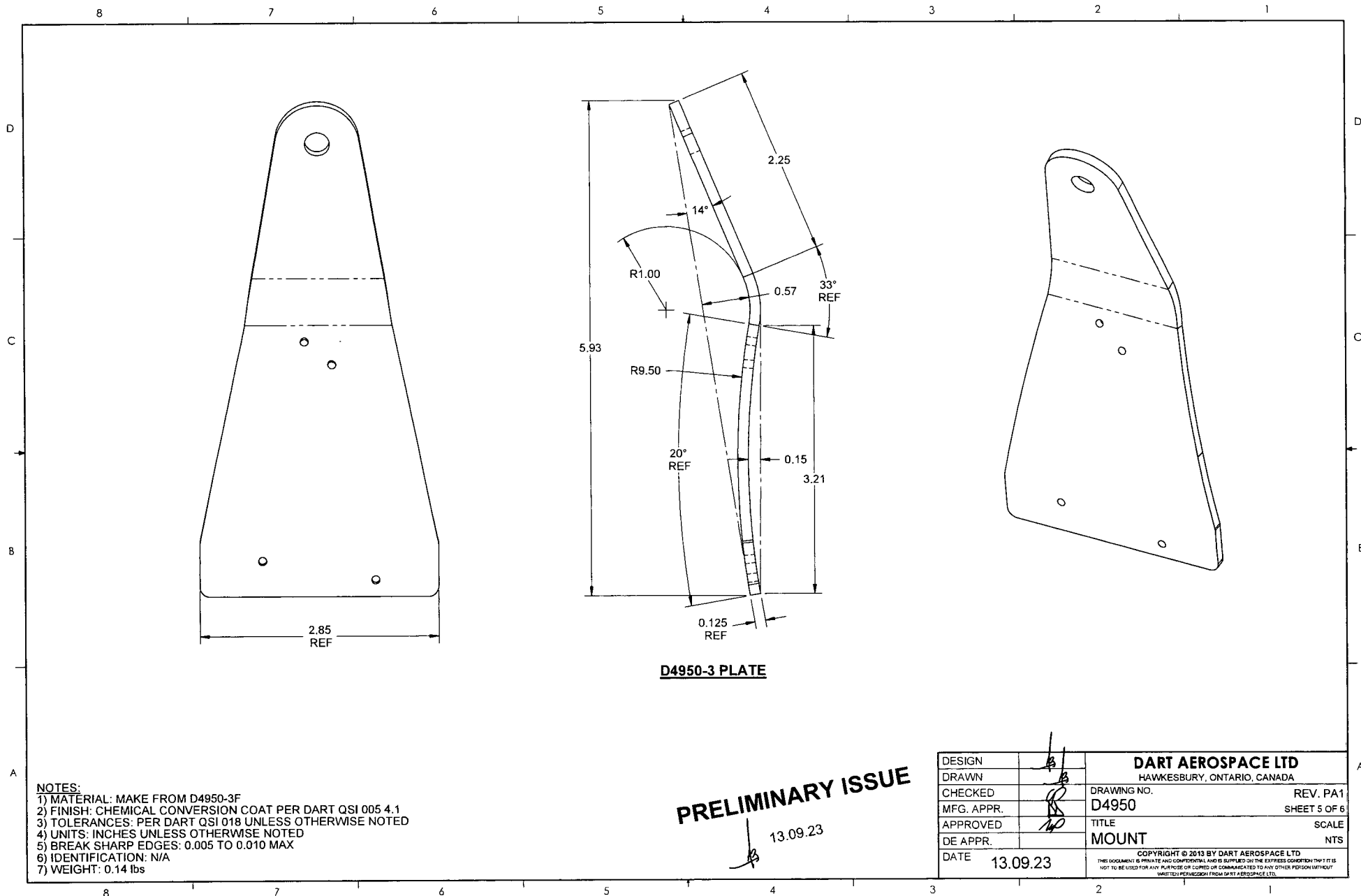
NOTES:

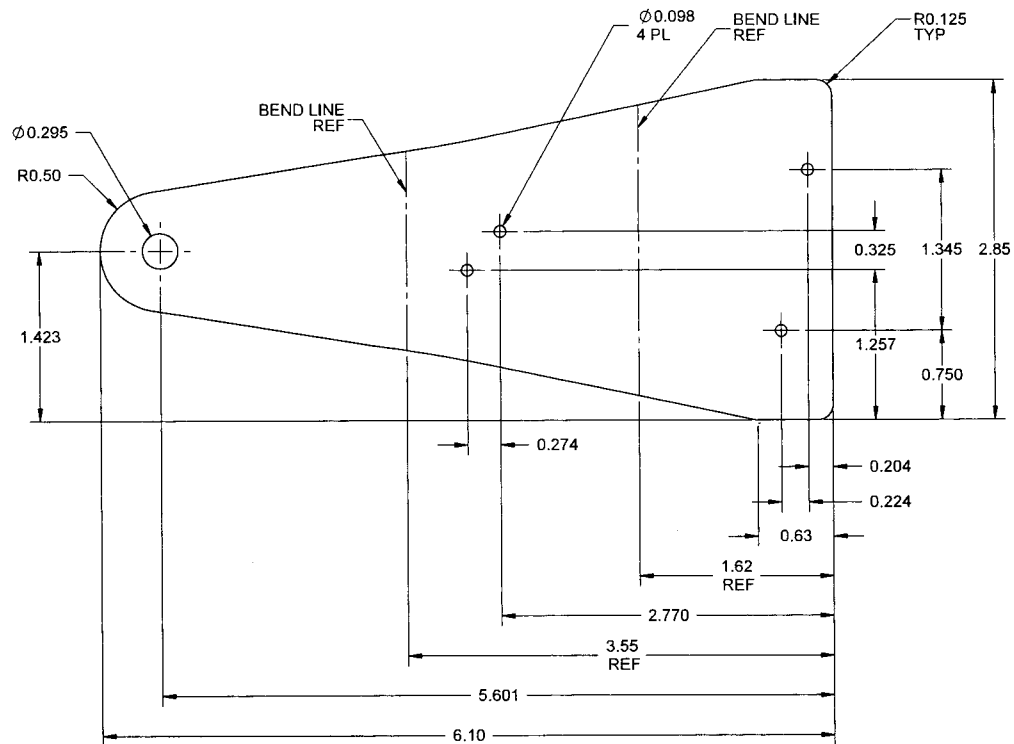
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

PRELIMINARY ISSUE

13.09.23

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4950	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
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D4950-3F FLAT PATTERN

NOTES:

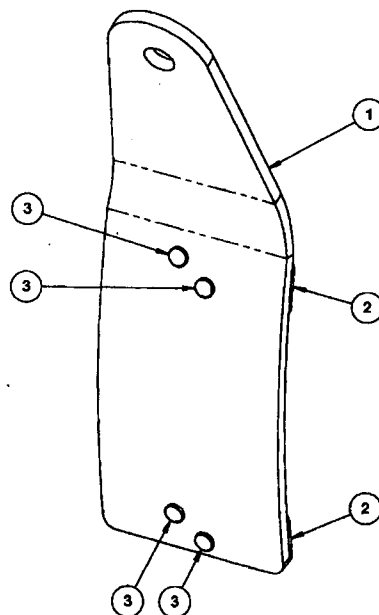
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC M6061T6S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

PRELIMINARY ISSUE

13.09.23

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4950	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
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ITEM NO.	QTY -041	PART NUMBER	DESCRIPTION
	X	D4950-041	TAILBOOM MOUNT
1	1	D4950-1	MOUNT
2	2	D3888-1	SPACER
3	4	MS20426AD3-6	RIVET



D4950-041 TAIL BOOM MOUNT

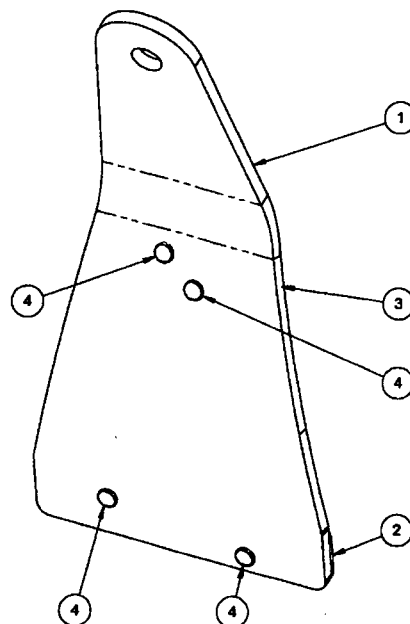
MF
#13-10-31
108950

RELEASED
2013-10-30

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4950-041" AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
 7) WEIGHT: 0.12 lbs

A	NEW ISSUE	MB	13.09.23
REV.		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		D4950	SHEET 1 OF 6
MFG. APPR.		TITLE	SCALE
APPROVED		MOUNT	NTS
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DATE	13.09.23		

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
	X	D4950-043	TAILBOOM MOUNT
1	1	D4950-3	MOUNT
2	1	D3868-3	SPACER
3	1	D3868-5	SPACER
4	4	MS20426AD3-6	RIVET

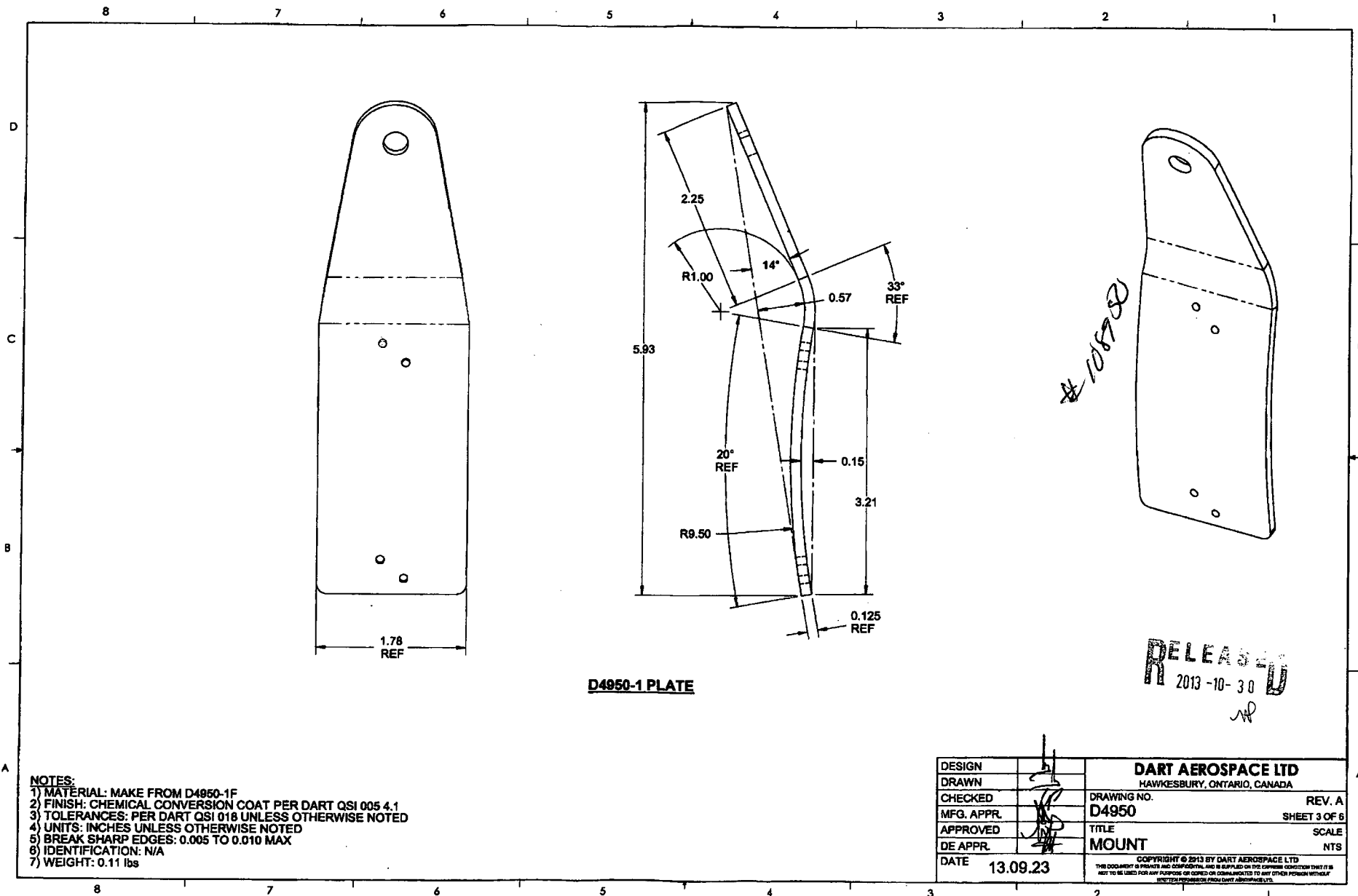


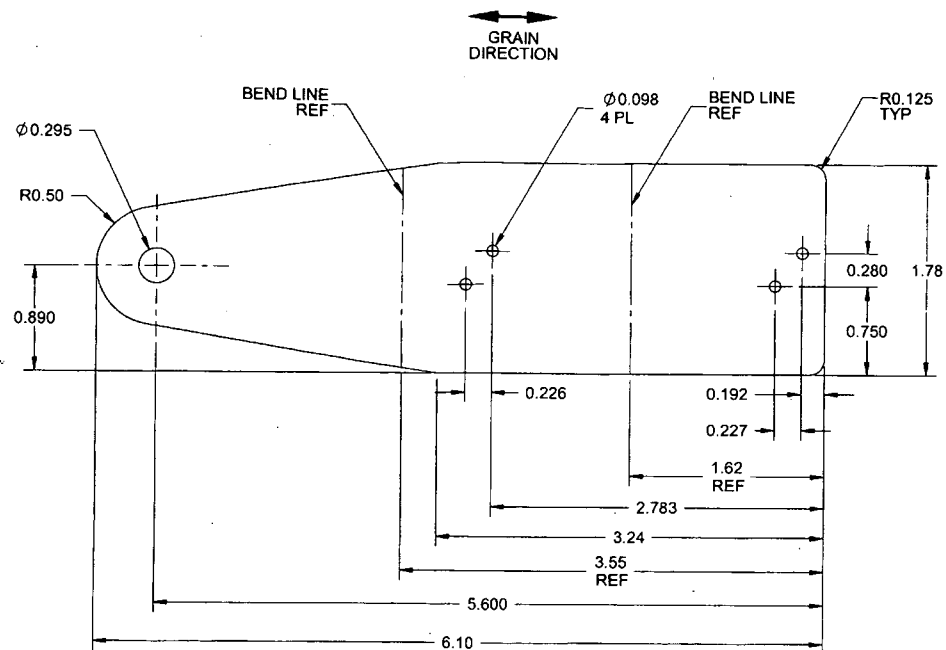
D4950-043 TAILBOOM MOUNT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4950-043" AND B/N PER DART QSI 044 8.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.15 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D4950	SHEET 2 OF 8
APPROVED			TITLE	SCALE
DE APPR.			MOUNT	NTS
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D4950-1F FLAT PATTERN

NOTES:

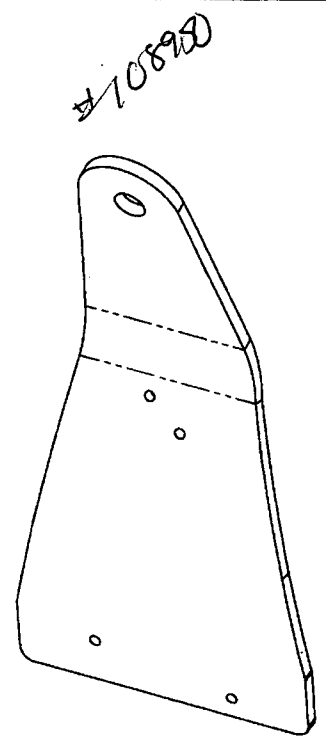
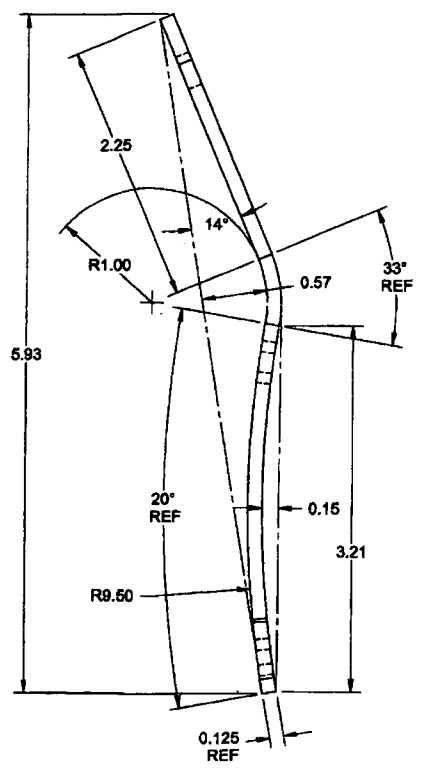
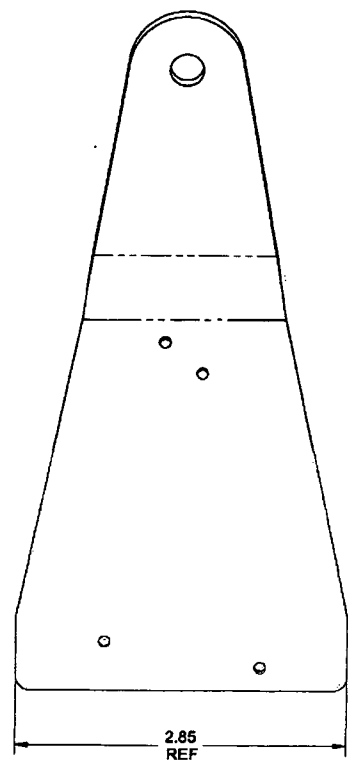
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC M6061T6S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.120.11 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4950	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
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RELEASED
2013-10-30
[Handwritten mark]

8 7 6 5 4 3 2 1

D
C
B
A



D
C
B
A

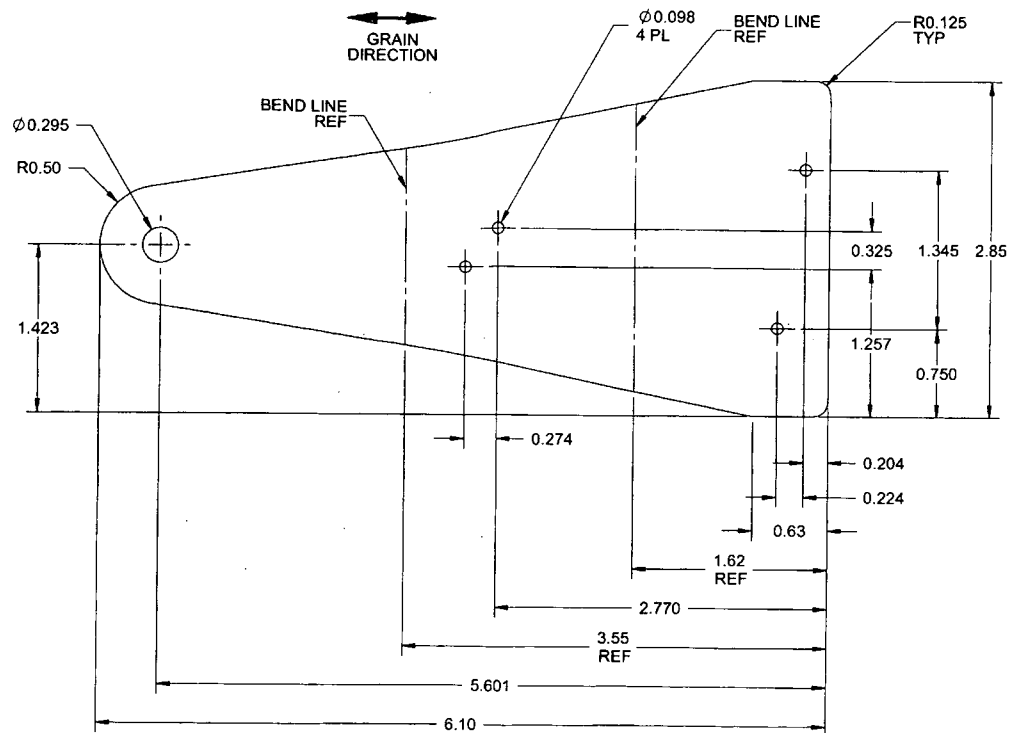
D4950-3 PLATE

RELEASED
R 2013-10-30 D

- NOTES:**
- 1) MATERIAL: MAKE FROM D4950-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.14 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4950	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
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8 7 6 5 4 3 2 1



D4950-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK PER AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.120.14 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4950	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
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